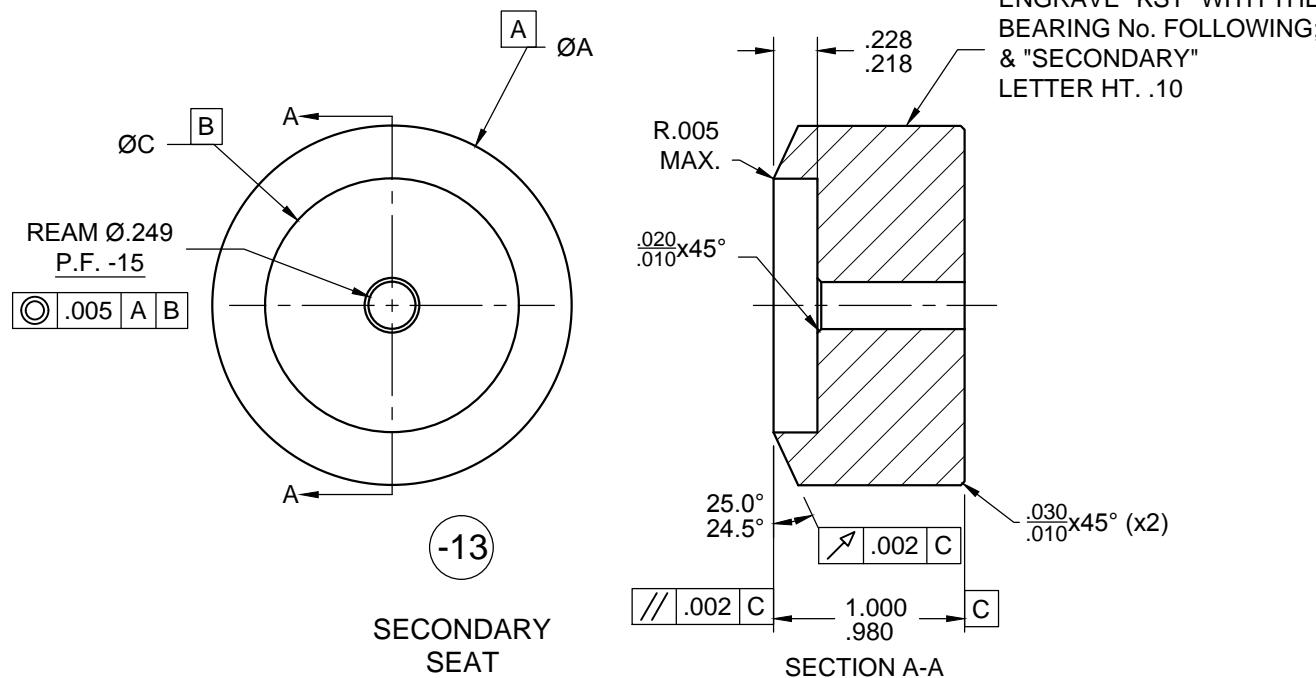


NOTES

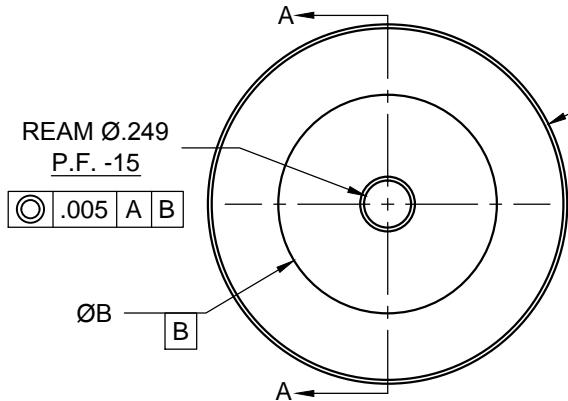
1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE	
TITLE KSTER## SERIES SWAGING TOOL; LOCATING PIN	
DWG NO. TOOL# (see chart)-15 REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $XXX \pm .005$ FRACTIONS $\pm 1/32$ $.XX \pm .01$ ANGLES $\pm .5^\circ$ $X \pm .1$	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	8-14-08
SHEET 9 of 9	

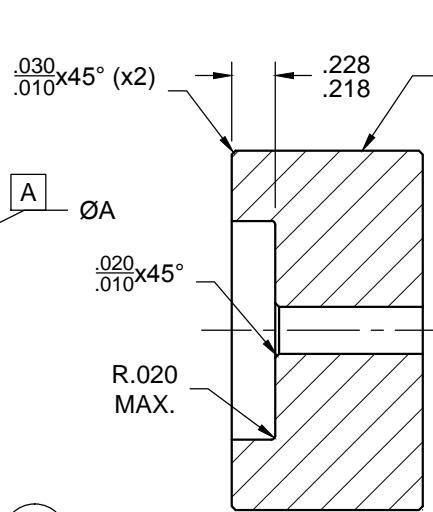


NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).



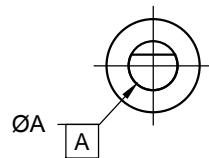
-11
**PRIMARY
SEAT**



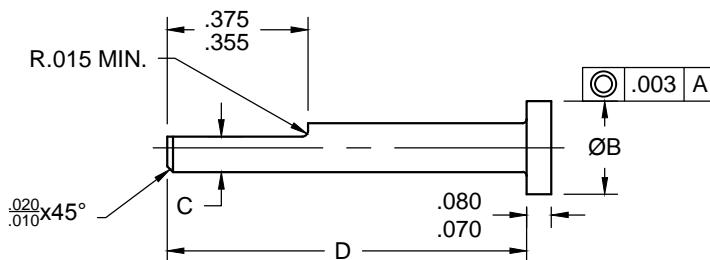
— ENGRAVE "KST" WITH THE
BEARING No. FOLLOWING;
& "PRIMARY"
LETTER HT. .10

NOTES

 RED BARN MACHINE	
TITLE	KSTER## SERIES
SWAGING TOOL; PRIMARY SEAT	
DWG NO.	TOOL# (see chart)-11
REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $.XXX \pm .005$ FRACTIONS $\pm 1/32$ $.XX \pm .01$ ANGLES $\pm .5^\circ$ $.X \pm .1$	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	8-14-08
SHEET 7 of 9	

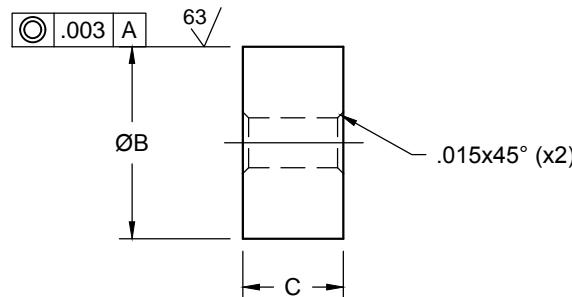
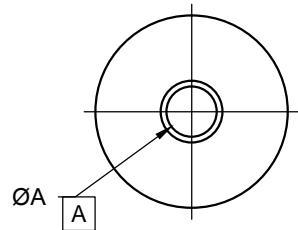


-9
PIN



NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

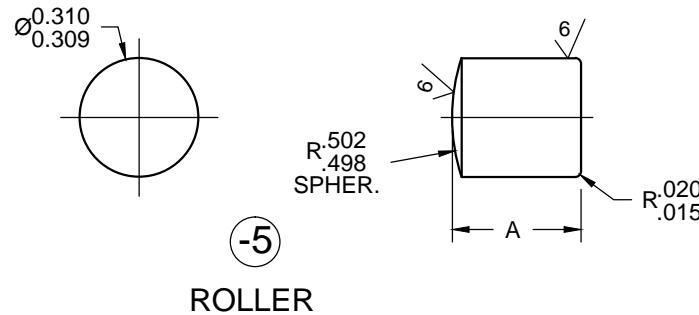


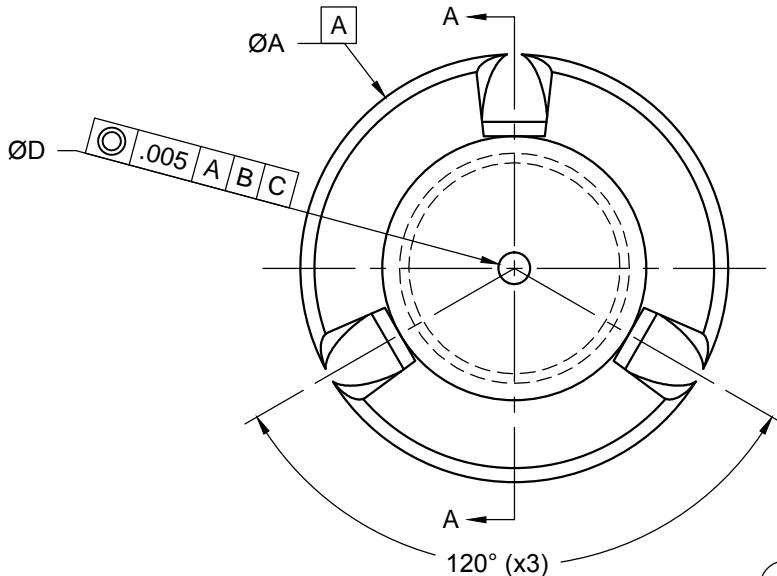
-7

GUIDE

NOTES

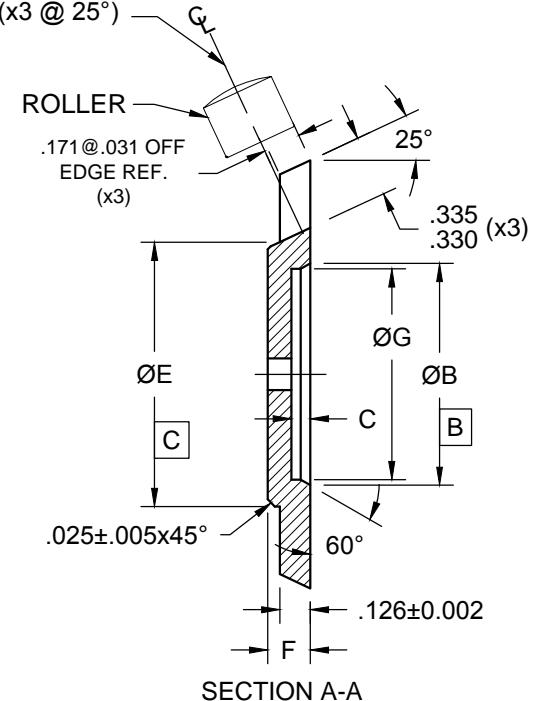
1. BREAK ALL SHARP CORNERS (.015/.03).





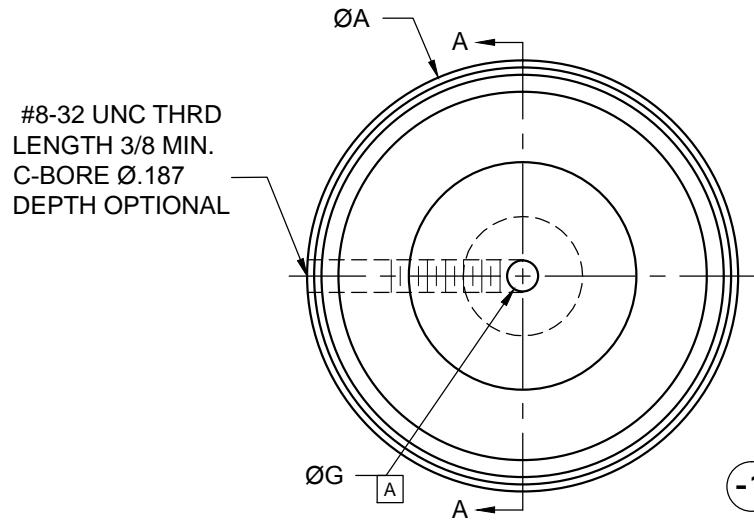
-3

RETAINER

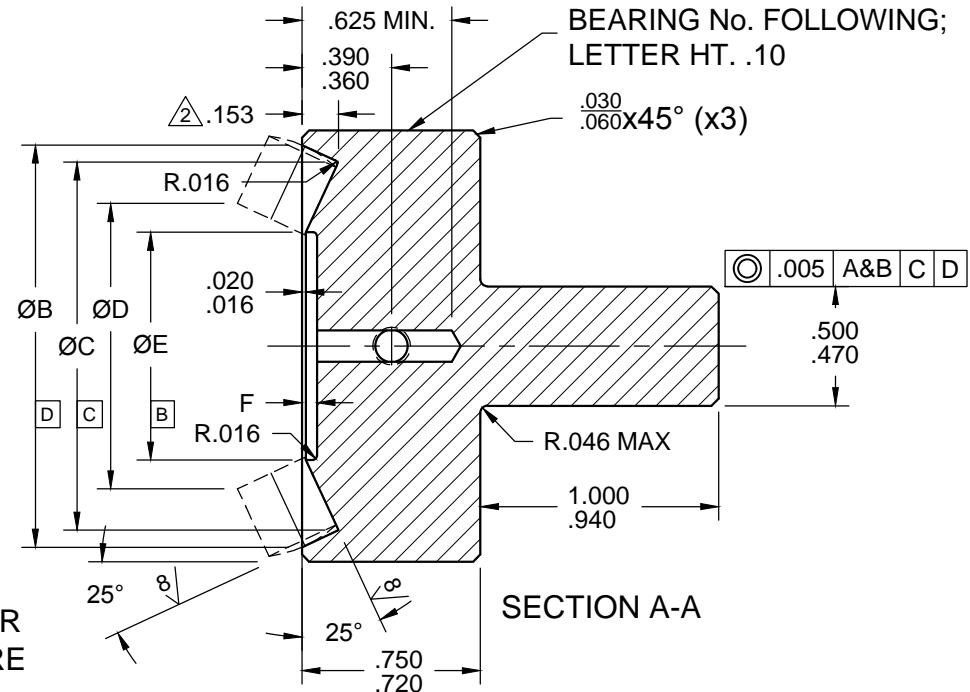


NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).



#8-32 UNC THRD
LENGTH 3/8 MIN.
C-BORE Ø.187
DEPTH OPTIONAL



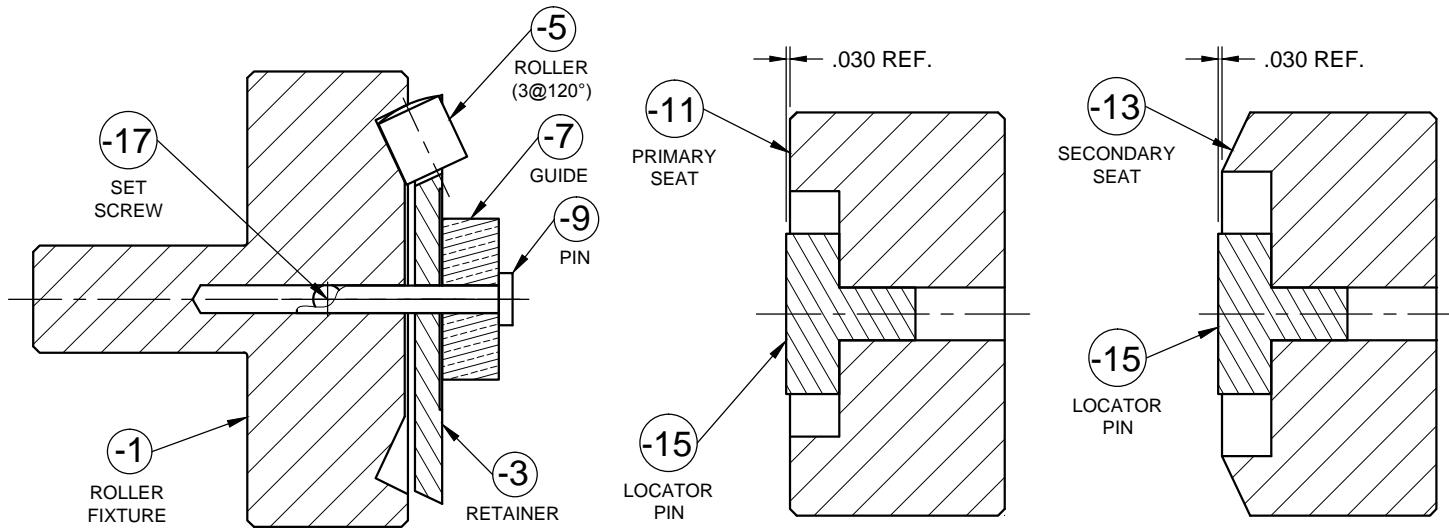
ROLLER FIXTURE

SECTION A-A

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).
2. DIMENSION TO BOTTOM OF R.016=.153;
DIMENSION TO SHARP CORNER=.158.
3. -1 BEARING RACE SURFACES MUST HAVE
SMOOTH APPEARANCE, FREE FROM
MACHINING MARKS AND GROOVES.
4. DO FIRST ARTICLE INSPECTION
BEFORE HEAT TREATING.

REV		DESCRIPTION		DATE	INITIAL	APPROVED
1		ADDED TOOL ERO4.		1/9/09	WP	-



NOTES

- 5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
- 5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
- FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.
- ENGRAVE AS SHOWN WITH "KST" & BEARING No.

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
BACB10ER04	KSTER04
BACB10ER05	KSTER05

 RED BARN MACHINE	
TITLE KSTER## SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10ER## BEARINGS	
DWG NO. TOOL# (see chart above); ASSEMBLY REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX \pm .005 FRACTIONS \pm 1/32	
XX \pm .01 ANGLES \pm 5°	
X \pm .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR. .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
HEAT TREAT LISTED PER ITEM	
FINISH SPEC LISTED PER ITEM	
DRAWN BY: PERRITT	
APPROVED	
USED ON BEARING	
SEE ABOVE	
SCALE	NTS
DATE	8-14-08
SHEET 1 of 9	

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		SEE CHART	1	SECONDARY SEAT	SEE CHART	8
				LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

SSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS
			-1	1	RND	6061	Ø8-1/4 x 3-7/8
ASSY #							

 RED BARN MACHINE	
TITLE	
DWG NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS	
XXX \pm .005	FRACTIONS \pm 1/32
XX \pm .01	ANGLES \pm 5°
X \pm .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.15 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	8-15-07
SHEET	1 of

REVISIONS					
REV	DESCRIPTION	DATE	INITIAL	APPR	
—	—	—	—	—	—

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	TITLE	RED BARN MACHINE
CHECKED		
HEAT		
TREAT		
FINISH SPEC		
USED ON MODEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
?	TOLERANCES ON: DECIMALS	
	XXX \pm .005	FRACTIONS \pm 1/32
	XX \pm .01	ANGLES \pm 5°
	X \pm .1	
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.015 x 45° PR. 0.015 R	
	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DWG NO.	PART #	REV.
SCALE	NTS	DATE 1-28-06
		SHEET 1 of 1

14

T #	QTY	DESCRIPTION
1	1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
3	1	BRASS RND Ø2 x 5/16
5	3	0-1 DRILL ROD Ø3/8 x 1/2
7	1	BRASS RND Ø3/4 x 3/8
9	1	1018 RND Ø1/4 x 1-1/8
11	1	1018 RND Ø1-7/8 x 1-1/8
13	1	1018 RND Ø1-7/8 x 1-1/8
15	1	1018 RND Ø3/4 x 3/4
		REVISION: 08-22-01

DRAWN BY:	PERRITT
APPROVED	
HEAT TREAT	
FINISH SPEC	BLACK OXIDE
USED ON MODEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
?	TOLERANCES ON: DECIMALS .XXX \pm .005 FRACTIONS \pm 1/32 .XX \pm .01 ANGLES \pm 5° .X \pm .1
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.15 x 45° PB 0.15 B

3	SECTION A-A	GUIDE	NOTES
<p>1. ENGRAVE 'WIN' CHARACTER HT. .090; 2. ENGRAVE 'PRIMARY' 3. ENGRAVE 'SECONDARY'</p>			
 RED BARN MACHINE			
TITLE: STAKING TOOLS			
DWG NO. RB ST1016			REV
SCALE	1/8	DATE	1 24 07
LTS		SHEET 1 - C 1	